

406 TWO PACK ETCH PRIMER

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Revised: Apr 2008

DESCRIPTION	A two pack Polyvinyl Butyral based etching primer designed to promote maximum adhesion of conventional top coats to properly cleaned ferrous and most non - ferrous metal surfaces.
PRODUCT NUMBER	<ul style="list-style-type: none">• Primer• Catalyst
FEATURES	<ul style="list-style-type: none">• 406 TWO PACK ETCH PRIMER provides excellent adhesion to ferrous metal and is recommended for use in a wide variety of industrial, automotive and marine applications and surfaces where good adhesion is not easily achieved. 406 TWO PACK ETCH PRIMER offers improved performance over single pack etch primers.
USES	<ul style="list-style-type: none">• As an adhesion promoting primer for iron, steel, aluminium and galvanised steel which are to be finished in both conventional air drying, stoving or Two Pack paint systems.
SURFACE PREPARATION	<ul style="list-style-type: none">• Ensure surfaces to be painted are clean and dry.• Remove dirt, oil, grease and other contamination by thorough washing with R123 HD WAX & GREASE REMOVER.• Acid or alkali contamination should be removed by washing with clean water.• Abrade steel surfaces to remove rust. Abrade all aluminium and zinc surfaces with a nylon abrasive pad and clean again with R123 HD WAX & GREASE REMOVER.• Apply 406 TWO PACK ETCH PRIMER immediately after preparation of the clean surface.
MIXING INSTRUCTIONS	<ul style="list-style-type: none">• Mix together 1 part by volume of 406-2004 TWO PACK ETCH PRIMER with 1 part by volume of 413-9116 TWO PACK ETCH PRIMER CATALYST.• Allow to stand 10 minutes before use.• Pot life of the mixed material is 6-8 hours under normal ambient conditions, however, do not mix any more material than will be used in two to three hours work.
APPLICATION	<ul style="list-style-type: none">• When mixed as detailed above, the material is ready for conventional spray application and further thinning is generally not necessary. However, R100 LACQUER THINNER can be used sparingly if further thinning is desired.• Apply by spray. Apply a light, even transparent coat. DO NOT ATTEMPT TO OBTAIN COVERAGE as application of heavy films can lead to serious adhesion problems. Brush application is only recommended for small areas.• PRECAUTION: Do not apply in conditions where relative humidity exceeds 65% or at ambient temperatures lower than 10°C, or when conditions are cold and damp.
COVERAGE	<ul style="list-style-type: none">• Recommended maximum dry film build is 10 microns, which corresponds with a spreading rate of approximately 10 m² / litre.

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- DRYING TIME**
- 5 - 10 minutes Tack Free
 - 30 Minutes Hard dry
 - Where the material is to be used under baking finishes, allow a short bake of 5 minutes at 100°C after 5 minutes flash off.
- RECOAT**
- 1 hour minimum at 25°C.
 - Do Not allow recoat time to exceed 12 hours.
- PACK SIZES**
- 1 Litre
 - 4 Litres

HEALTH AND SAFETY

Contains Zinc Tetroxy Chromate and flammable volatile solvents. Keep away from all sources of heat and open flames. Do not smoke whilst handling. Wear suitable protective clothing to avoid contact with skin and eyes and avoid breathing vapour. Do not spray in confined or poorly ventilated areas without the use of approved air supplied breathing apparatus.

FIRST AID

- Eyes** If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
- Skin** If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use.
- Inhalation** If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
- Ingestion** If swallowed, give glass of water to drink and seek medical assistance. **DO NOT** induce vomiting.

Consult separate Material Safety Data Sheet for more detailed Health and Safety information.